

Work Order ID 136225

Monday, August 31, 2015 8:29:00 AM

136225

Page 1

Item ID: D119-827-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lockout

Start Date: 8/21/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-827	D								

100 Document Control 0.00
100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D119-827-011 CHG002

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging


 OCT 19 2014
 DAS 6 27
 9-89 9-89

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.00
 Quality Control


 OCT 19 2015
 DAS 28
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

Work Order ID 136225

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136225

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lockout

Start Date: 8/21/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2x	DAS 28		OCT 19 2015
Packaging	Memo	0.00					9-89		
Packaging	Identify and pack for shipping as per PPP D119-827-011 Location: <u>FG121</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00					MCS		OCT 19 2015
Quality Control									

MCS OCT 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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136225

D119-827-011

Required Date: 8/28/2015

Required Qty: 2.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP
REV:B 13-01-09 REV B JLM VERIFIED:DD IPP REV:C
12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041		Manufactured	No			110	Each	2.0000	1	2			BAS 27 9-89
D4704-041 Expandable Pin Assembly DAS 28 9-89 ** B124635 DAS 6 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST123			2						
				134482			2						
D4703-041		Manufactured	No			110	Each	2.0000	2	4			BAS 27 9-89
D4703-041 Lock Pin Assembly DAS 28 9-89 ** 136577 DAS 6 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST123			2						
				127873			2						
D4710-1		Manufactured	No			110	Each	7.0000	1	2			BAS 27 9-89
D4710-1 Spacer DAS 28 9-89 ** 135997 DAS 6 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST123			7						
				127249			7						
D4721-1		Manufactured	No			110	Each	4.0000	1	2			BAS 27 9-89
D4721-1 Decal DAS 28 9-89 ** 135997 DAS 6 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST121			4						
				127250			4						

DAS 6 9-89
OCT 19 2014

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition			Completed By																		
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Root Cause		FAULT CATEGORY																							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐														
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐														
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Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐														
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐														
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																					
Misidentified	☐	Past Due	☐																						

Picklist Print

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Work Order ID: 136225

136225

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 8/21/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

AN4-11A Purchased No

110 Each 64.0000 2 4

2 ***AN4-11A***
BOLT

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG 20
120731 20
ST325A 44
M128362 44

DAS
6
9-89

MS14144L4 Purchased No

110 Each 24.0000 2 4

2 ***MS14144L 4***
Nut

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST316 24
m132680 24

MS24665-153 Purchased No

110 Each 79.0000 2 4

2 ***MS24665-153***
Cotter Pin

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST294 79
107139 79

NAS1149D0416J Purchased No

110 Each 4,678.000 2 4

2 ***NAS1149D0416J***
WASHER

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 374
m131511 374
ST270 4304
m131511 4304

OCT 19 2015

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

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Page 3

Work Order ID: 136225

136225

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 8/21/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

2,604.000

8

16

2 *NAS1149D0463J*

WASHER

**

M132035

DAS 27
6 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1563

M129682

86

M130799

371

M132035

981

M132317

125

NAS6604D16

Purchased

No

110

Each

41.0000

2

4

2 *NAS6604D16*

Bolt

**

OCT 19 2014

DAS 27
6 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST262

41

m131616

41

4

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

4.0 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

The following are the net weight increases associated with D119-827-011 kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 ON A109/A119 MODELS	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 ON 206/407 MODELS	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg